

Work Order ID 150403

Wednesday, August 24, 2016 11:51:38 AM

150403

Page 1

Item ID: D119-796-251 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AFT Crosstube Installation with Step (no hardware)
Start Date: 8/16/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/12/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: **DAS 21** Date: Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: **AUG 29 2016** SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-251	D								

110

Document Control

0.00

110

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels as per PPP D119-796-251 chg 002

N/A

120

Pick Kit
Packaging

0.00

120

Packaging

Memo

0.00

Packaging

1

16.11.27

130

Crosstubes

0.00

130

Crosstubes

Memo

0.08

Crosstubes

1- Install step and clamp with the proper position per dwg D119-796-251

Torque all clamps to 50 IN-LBS max.

1

16.11.27

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***RE-CHECK TORQUE ON CLAMP AS PER DWG.*** ***VERIFY BY <u>38</u> BATCH # TO MATCH W/O <u>150403</u> ***VERIFY BY <u>38</u> PART # TO MATCH W/O <u>150403</u>	0.00 0.00				<u>1</u>			JAS 38 9-89
150 *150* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D119-796-251	0.00 0.00				<u>1</u>			<u>AVI</u> 16-11-28
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							16/11/29 16-11-28

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 150403

150403

Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 8/16/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B
14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19
AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER
REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D
JLM VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-796-241

Manufactured No

Each 1.0000

1

D119-796-241

149516

**

AFT Crosstube Installation without Step (no hardware)

16.11.16

Location

Loc Qty

Loc Code

FG

1

146580

1

D5123-3

Manufactured No

Each 100.0000

4

D5123-3

Clamp Cushion

**

16.11.16

Location

Loc Qty

Loc Code

LG054

12

147939

12

LG055

88

146879

28

148184

24

149113

36

D5149-043

Manufactured No

Each 8.0000

2

D5149-043

Aft Step Base Assembly

**

16.11.27

Location

Loc Qty

Loc Code

LG055

8

142738

6

149108

2

146877

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID: 150403

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Parent Item: D119-796-251

D119-796-251

Parent Item Name: AFT Crosstube Installation with Step (no hardware)

Start Date: 8/16/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-25

Purchased

No

Each

11.0000

4

MS21920-25

Clamp

MP
16-11-16

Location

Loc Qty

Loc Code

FG **135787**

4

4

120920

2

m134987

2

LG050

7

m135444

7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

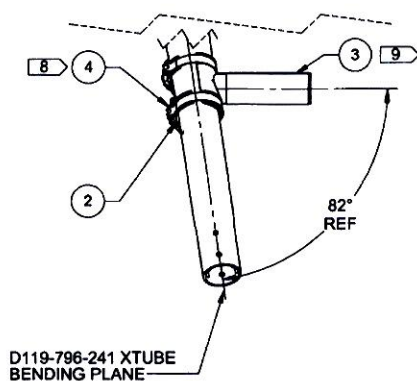
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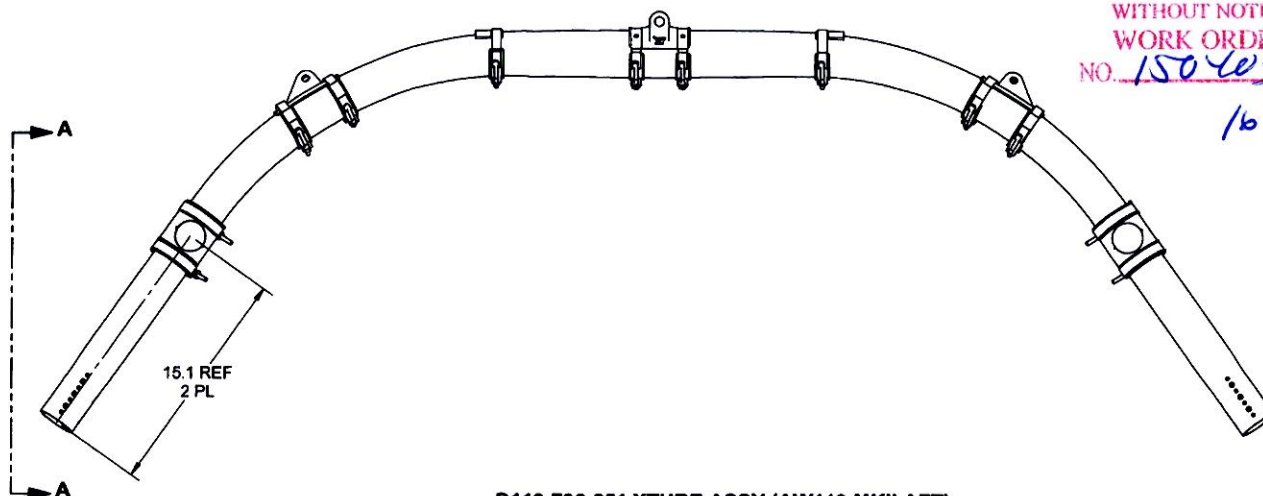
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ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150403 M/S
160



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	DB		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	15.01.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D119-796-251

REV. D
SHEET 1 OF 1

TITLE
XTUBE ASSY (AW119 MKII AFT) NTS
SCALE

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